

Lush

135724



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4423-1

Job Sheet 168520



Part No: D4423-1

Job Qty: 2 ea

Part Name: Splash Guard Extension



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/16/17

Job Tracking No:

Due Date: 11/24/17

Created By: Sylvie Boucher

Type: Stock

Description:

Note: D4423 REV A IPP revA 11.06.30 new issue EC verified by:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea		11/23/17	0.00	0.00	Start Up Waterjet		SR
100	Waterjet	2 pcs		11/23/17	0.00	0.07	Waterjet1		SR
110	QC	2 pcs		11/23/17	0.00	0.00	QC2 Waterjet-4		SR DAS
115	QC	2 pcs		11/23/17	0.00	0.00	QC8-1		SR 38
117	Brake NC	2 pcs		11/23/17	0.00	0.00	Brake NC 1		SR DAS
119	QC	2 pcs		11/23/17	0.00	0.00	QC5		SR 38
120	HandFinish	2 pcs		11/23/17	0.00	0.04	HandFinish1		2017-11-22 JSL
130	QC	2 pcs		11/23/17	0.00	0.00	QC7		BL 17-11-22
134	Powdercoat	2 pcs		11/24/17	0.00	0.20	Powdercoat3		BL 17-11-23
136	QC	2 pcs		11/24/17	0.00	0.00	QC3		SR 38
140	Packaging	2 pcs		11/24/17	0.00	0.00	Packaging3-1	Storil	SR 21
150	QC21-SA	2 Ea		11/24/17	0.00	0.00	QC21		NOV 23 2017

Part Op 100 - **GRAIN DIRECTION** 1-Cut as per Dwg Dwg Rev: A Prog Rev: A 2-Debur if necessary

Descriptions: 134 - START TIME: 7:30 OVEN TEMPERATURE: 350° FINISH TIME: 8:20

M 122877. GLOSS GRAY.

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M6061T6S.032	1	129	0	0

Part Specifications

Specifications could not be found.

Plex 11/16/17 7:40 AM dart.boucher.sylvie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS			
	Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐			

Date : _____ Step #: _____

MRB (QS1042) Approval

Description Work Order D

Job No: 168520
Mfg Date: 11/16/17

Start up Operation

D4423 - 1

Change No:

Operation:

Revision:

PART NO:

Completed By

Lead hand / Supervisor
Approval Verification

Splash Guard Extension



QC / QA Coordinator
Approval

S010744



Positioned Wrong
outside Dimensions

Over/Under tolerance

Root Cause			
Environment ☐	No Re-verification ☐	Pressu ☐	
Design ☐	Operator ☐	Bendin ☐	
Doc/Data ☐	Offset/Setup ☐	Centre ☐	
Equip/Tooling ☐	Supplier ☐	Cracks ☐	
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	
Material ☐	Use for Testing ☐	Cuffs ☐	
Internal Transport ☐	Poor Information ☐	Crushing ☐	
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	
Past Expiry Date ☐	Manufacturing Process ☐		
Misidentified ☐	Past Due ☐		
		OTHER :	

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

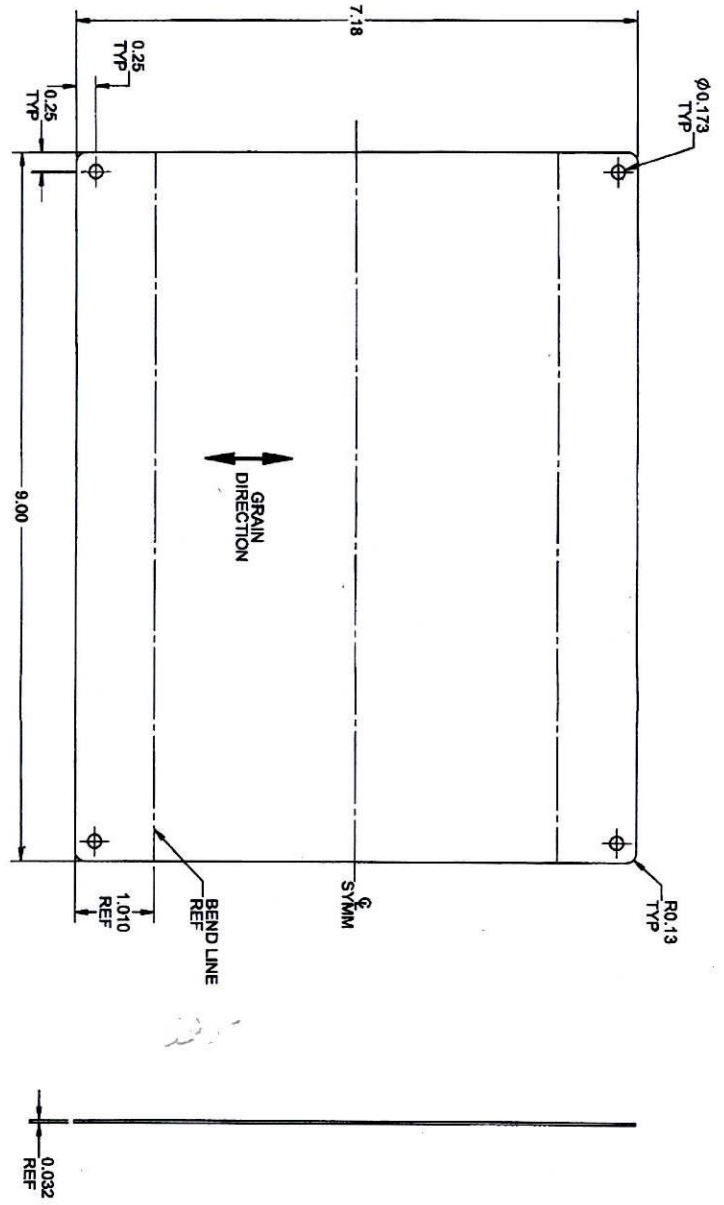
Inspection Incomplete/Unqualified
Contamination
Countersink
Cut Too Short
Instructions Incomplete/Unclear
Drill Holes

Weld
Wrong Stock Pulled
Out of Sequence
Off-set
Mislabelled
Fit/Function
Misaligned/off center

Part Incorrect
Part Lost/Missing
Part Moved
Drawing
Finish
Misread
Turning Sequence

- NOTES:
- 1) MATERIAL: 6061-T6/62 ALUMINUM SHEET, 0.032 THICK, PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209 REF DART SPEC M6061T6S.032
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.20 lbs

D4423-1F SPLASH GUARD EXTENSION FLAT PATTERN



DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		
DATE	11.06.22	
TITLE	D4423	REV. A
SCALE	SPLASH GUARD EXTENSION	SHEET 2 OF 2
NTS		

RELEASED
2011-07-06

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 168520

DAS
30
9-89

NOV 16 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

8 7 6 5 4 3 2 1

D

D

C

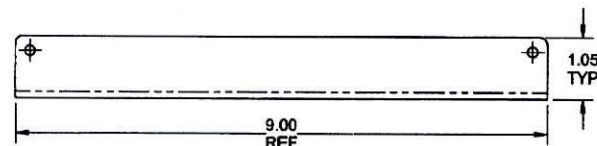
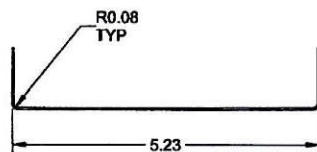
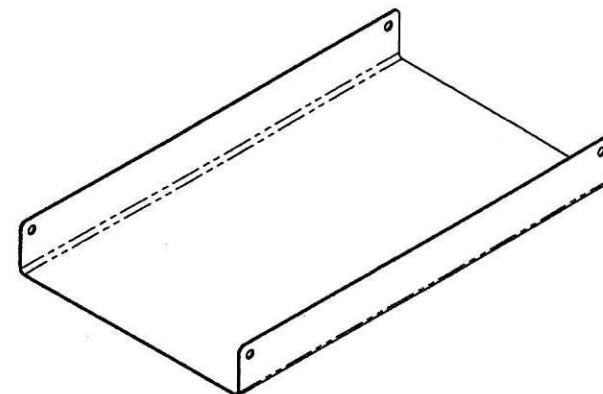
C

B

B

A

A



D4423-1 SPLASH GUARD EXTENSION

RELEASED
2011-07-06

NOTES:

- 1) MATERIAL: MAKE FROM D4423-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4423-1" AND B/N PER QSI 044 6.1
- 7) WEIGHT: 0.20 lbs

*Gloss Grey
AS PER
ATTACHED
E-MAIL*

[Signature]

REV.	NEW ISSUE	DESCRIPTION	MB	11.06.22
DESIGN				
DRAWN				
CHECKED				
MFG. APPR.				
DE APPR.				
DATE	11.06.22			

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4423	REV. A
TITLE SPLASH GUARD EXTENSION	SCALE NTS

COPYRIGHT © 2011 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE LTD.

8 7 6 5 4 3 2 1

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐			FAULT CATEGORY Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		
OTHER : ☐					

Jean-Luc Menard

From: Harvey Siemens
Sent: Wednesday, November 22, 2017 3:49 PM
To: Jean-Luc Menard
Subject: RE: d4423-1 Powder coat

JL,

I would accept that deviation to the finishing as painting it would actually match the part that it attaches to.

Regards,
Harvey Siemens
Director of Engineering – Calgary

DART AEROSPACE
T 1 403 717-0328 > 402
M 1 403 512-4099
www.dartaerospace.com



From: Jean-Luc Menard
Sent: Wednesday, November 22, 2017 1:48 PM
To: Harvey Siemens <hsiemens@dartaero.com>
Subject: d4423-1 Powder coat

Is it acceptable to paint this gloss grey vs grey sandtex?
JL

Jean-Luc Menard
Director of Operations

DART AEROSPACE
T 1 613 632-5200 > 227
F 1 613 632-5246
1 800 556- 4166
www.dartaerospace.com

